




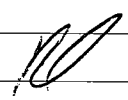




Work Order ID 65144

Thursday, January 06, 2011 2:42:37 PM

Page 1




Item ID: D3290-041 Accept  Setup Start 
Revision ID: Stop 
Item Name: Replacement Window Assembly
Start Date: 1/6/2011 Start Qty: 8.00  Cust Item ID:
Required Date: 1/14/2011 Req'd Qty: 8.00  Customer:
Reference:

Approvals: Process Plan:  Date: 1/01-6 Tooling: Date: Run Start 
QC: Date: SPC (Y/N): Date: Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3290	DEO Rev C1								

100		0.00							
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	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3290 (use prog. for D3290-1) Dwg Rev:  Prog Rev:  2-Deburr if necessary								

B11-1-10




110	QC2- Inspect parts off machine FAI/FAIB	0.00							
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QC	Memo	0.00							

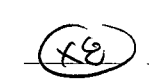
B11-1-10

120	QC8- Inspect parts - second check	0.00							
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QC	Memo	0.00							

Quality Control									
-----------------	--	--	--	--	--	--	--	--	--

5/10/10



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65144

Thursday, January 06, 2011 2:42:37 PM



Page 2

Item ID:	D3290-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Replacement Window Assembly					
Start Date:	1/6/2011	Start Qty:	8.00			
Required Date:	1/14/2011	Req'd Qty:	8.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00							
	Memo	0.00							
Hand Finishing									
140 Powdercoat	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
	Memo	0.00							
Powder Coating	START TIME: 9:30 OVEN TEMPERATURE: 300° FINISH TIME: 10:00								
150 QC	QC3- Inspect Part Finish	0.00							
	Memo	0.00							
Quality Control									

=> JH

11/01/10

VS

Q

M 115951

8 H 11-01-13

8 JH 11/01/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____


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NOTE: Date & initial all entries

Thursday, January 06, 2011 2:42:37 PM

Page 3

Item ID:	D3290-041	Accept		Setup	Start	
Revision ID:						
Item Name:	Replacement Window Assembly				Stop	
Start Date:	1/6/2011	Start Qty:	8.00		Cust Item ID:	
Required Date:	1/14/2011	Req'd Qty:	8.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:			

[illegible]

W/O: 65144		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/12/08	160	HL 1 same only D3290-1 using same B/N			1	HL 10/07/08	S 11/02/08

Part No: D3290-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 65144

Thursday, January 06, 2011 2:42:37 PM



Page 4

Item ID: D3290-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Window Assembly

Start Date: 1/6/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/09 *[Signature]*

MF
11-02-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Thursday, January 06, 2011 2:42:43 PM

Page 1

Work Order ID: 65144

Parent Item: D3290-041

Parent Item Name: Replacement Window Assembly

Start Date: 1/6/2011


Required Date: 1/14/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP B05.05.25 Added Step 11 KJ/JLM
 IPP C06.05.09 Ecn 798 EC
 IPP Rev:D Now on Waterjet 06-06-16 JLM
 IPP rev E rev C dwg 07.09.28 EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.063		Purchased	No			100	sf	147.2340	3.75	31.57895			
													
6061-T6 .063 Sheet													

Location	Loc Qty	Loc Code
MAT	109.6	
116308	109.6	
MAT21	37.634	
113608	37.634	

Bill-1-10


8

116308

D2126		Manufactured	No			160	f	22.0884	6.5	52			
													
Seal													

Location	Loc Qty	Loc Code
ST405	22.08842105	
48285	22.0884211	

(D2126-0780) cut qty (1) at 78.00" as per dwg
 per kit

D3290-3		Manufactured	No			160	Each	2.0000	1	8			
													
Window													

Location	Loc Qty	Loc Code
ST221	2	
57837	2	

B65643

REV C

7

SAO 11-02-08

52

SAO 11-02-08

W/O:		WORK ORDER CHANGES					
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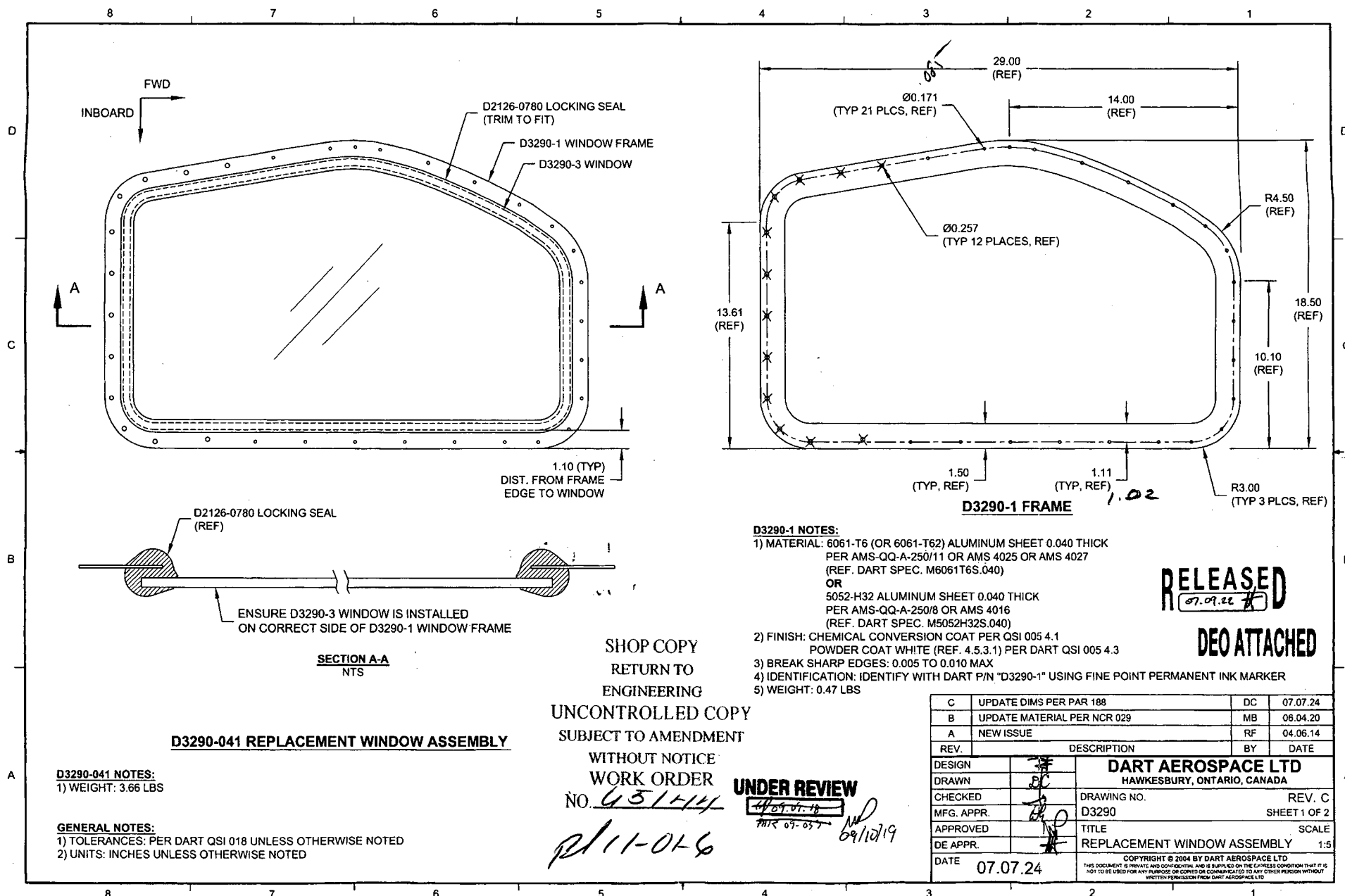
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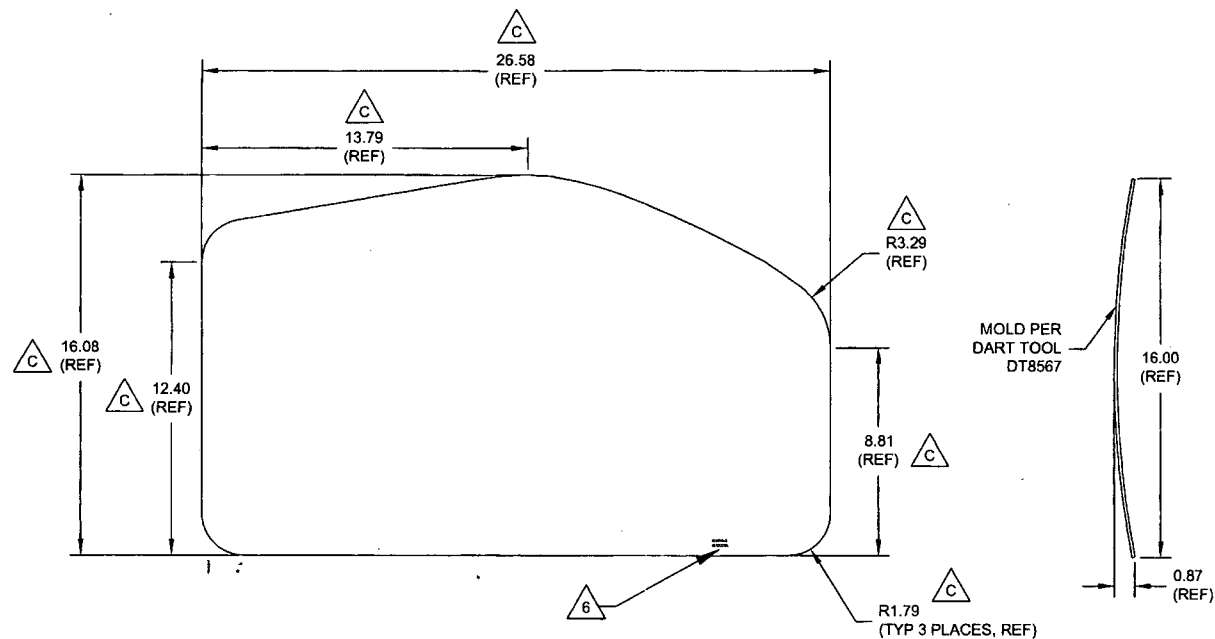
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D3290-3 WINDOW

D3290-3 NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425
OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER
LP-391 TYPE 1 GRADE C, 0.125 THICK
(REF. DART SPEC. M-ACRYLIC-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3290-3" AND B/N ON LOWER EDGE
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 1.87 +/- 0.42 LBS
- 8) MOLD PER DART TOOL DT8567

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3290	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		REPLACEMENT WINDOW ASSEMBLY	1:5
DATE	07.07.24	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

UNDER REVIEW

DEO ATTACHED
RELEASED

w/o 65144

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DRAWING NO. D3290	TITLE REPLACEMENT WINDOW ASSEMBLY	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3290-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>q</i>	CHECKED <i>b</i>	MFG. APPR. <i>EZ</i>	APPROVED <i>MP</i>		DE APPR. <i>#</i>		
DATE 09.09.18	DATE 09.09.18	DATE 09.09.18	DATE 09/09/21		DATE 09/09/21		

PURPOSE:

CHANGE MATERIAL THICKNESS OF D3290-1 FRAME TO 0.063 FROM 0.040. REF PAR 09-033.

CHANGE:

MATERIAL CALL-OUT OF D3290-1 FRAME ON SHEET 1 IS AMENDED AS FOLLOWS:

D3290-1 NOTES

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
~~(REF. DART SPEC. M6061T6S.040)~~ REF. DART SPEC. M6061T6S.063 (REPLACE)
 OR
 5052-H32 ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/8 OR AMS 4016
~~(REF. DART SPEC. M5052H32S.040)~~ REF. DART SPEC. M5052H32S.063 (REPLACE)

wlo 65149

RELEASED
 2009 -10- 09

MP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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